

Date:
User:Tuesday, 01/05/2007 2:18:53 PM
Linda Lacelle

Process Sheet

split
SD 07/05/14

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 31867-1
 Estimate Number : 12806
 P.O. Number : NA
 This Issue : 01/05/2007 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NA Type : SMALL /MED FAB
 Previous Run : 31867
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est Rev: A New Issue 07-03.26 ec

Drawing Name : BRACKET
 Part Number : D35702
 Drawing Number : D3570 REV EC 07.06.07
 Project Number : N/A
 Drawing Revision : EC 07.06.07
 Material : NA
 Due Date : 13/05/2007 Qty: 60 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 4.4730 sf(s)

6061-T6 .125 Sheet

Batch: M103156

Grain must be Along 4.63"**

SAD 07/05/04

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: BProg Rev: B

2-Deburr if necessary

SAD 07/05/04
MF 07-05-07 60 (PTO)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/04 60

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07.05.04 60

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

FF 07-05-11 60
SAS 07/06-04 34

Form as per Dwg D3570

Date: Tuesday, 01/05/2007 2:18:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31867

Part Number: D35702

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job. 12 34

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AS 07-06-13 34

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 101601 BK 07-06-13 34

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/06/14 26 + 8 GA

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: *243A*

07/06/14 26 + 8 GA

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/14

Job Completion



11 07-06-14

Date: Tuesday, 4/17/2007 11:13:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31867	
Estimate Number : 12806	
P.O. Number :	Part Number : D35702
This Issue : 4/17/2007 S.O. No. :	Drawing Number : D3570 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : 31479	Material :
Written By :	Due Date : 5/12/2007 Qty: 60 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-03.26 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0746 sf(s)/Unit Total : 4.4730 sf(s)
 6061-T6 .125 Sheet
 Batch: _____

Grain must be Along 4.63"**

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3570
 Dwg Rev: _____
 Prog Rev: _____

2-Debur if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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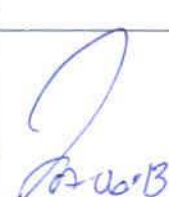

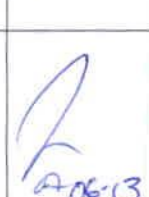
Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3570

PTO
 →

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
02/05/14	5	Split u/o	SP	07/05/14	35			

Part No: D3570-2 PAR #: N/A Fault Category: Prod / Proc Ass ^{med & small} NCR: Yes No DQA: TD Date: 07/05/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/04	20	wrong dimensions on program and wrong grain direction. Scrap one piece		Scrap & destroy and replace	SAD 07/05/04	 07/05/04		 07/05/04
07/06/04	5	6 piece were scrap hole out of tolerance		Scrap & destroy	SPS 07/06/04	 07/06/04		 07/06/04

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31867

Part Number: D35702

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock
Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

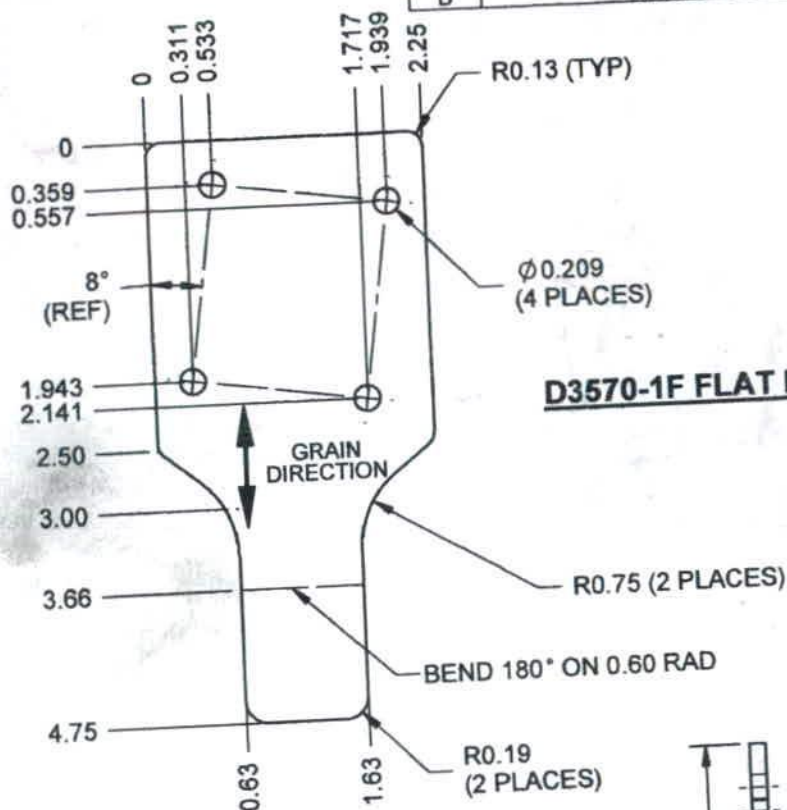
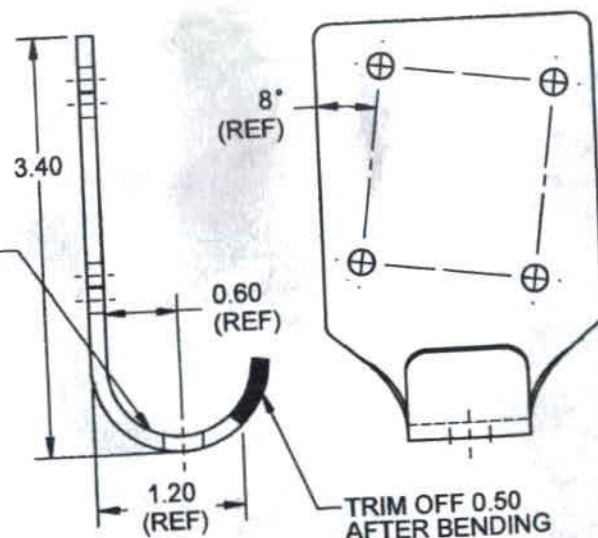
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3570	REV. B SHEET 1 OF 1
DATE 07.04.16	TITLE BRACKET	SCALE 2:3	
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	

**RELEASED**07.04.25 *H***D3570-1F FLAT PATTERN**DRILL $\phi 0.328$ AFTER BENDING
CENTERED ON PART & ON BEND**D3570-1 BRACKET SHOWN
(MAKE FROM D3570-1F)****D3570-2 BRACKET OPPOSITE
(MAKE FROM D3570-1F)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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Work Order: 31867

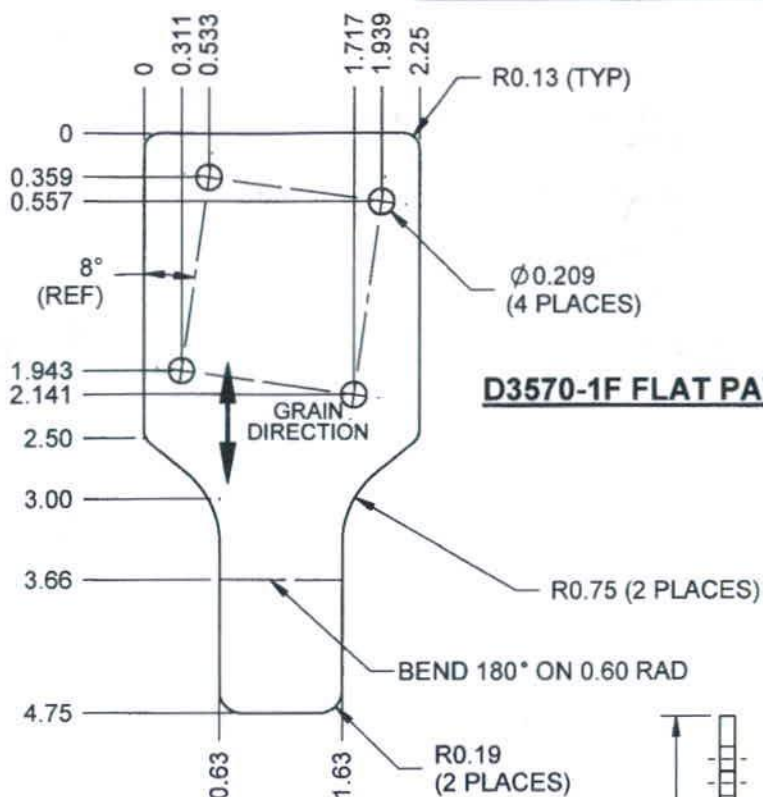
Part Number: D35 702

☒ First Article ☐ Prototype

Measured by: SAD		Audited by: SP		Prototype Approval: W/A	
Date: 07/05/04		Date: 07/05/04		Date:	
Rev	Date	Change			Revised by
		New Issue			KJ/RF
					Approved

DART

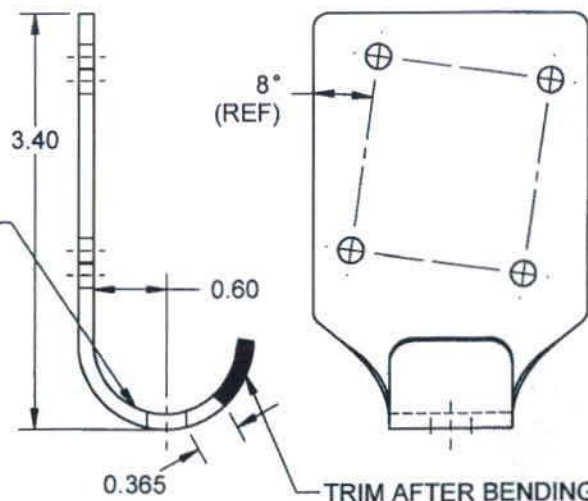
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1
DATE 07.06.01	TITLE BRACKET SCALE 2:3		
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	
C	07.06.01	UPDATE DIMS FOR CLARITY	

**D3570-1F FLAT PATTERN****RELEASED**07.06.01 *H*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. B31867

D3570-1 BRACKET SHOWN
(MAKE FROM D3570-1F)

D3570-2 BRACKET OPPOSITE
(MAKE FROM D3570-1F)

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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